

Work Order ID 84916

May-29-12 1:09:00 PM

84916

Page 1

Item ID: D209-669-014

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube RH

Stop

NS2Start Date: 29/05/2012 Start Qty: 1.00 ***1***

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 ***1***

Customer:

Reference:

Approvals: Process Plan: MLJDate: 12/05/13 Tooling:

Date:

Run Start

NR1

QC:

Date:

SPC (Y/N):

Date:

Stop

NR2

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
Draw Nbr	Revision Nbr								
D209-669-014	Rev B								
DSI 9450	Rev A								
100 *100* DC Document Control	DOCUMENT CONTROL Memo Photocopy bluefile & type labels per PPP D209-669-014 CHG003	0.00 5.0 DAS 16 9-16 004 per ECN 12.599							
110 *110* Packaging Packaging	Pick Kit Memo	0.00 0.00							<u>12/1/13</u>

86334

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Work Order ID 84916

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Page 2

Item ID: D209-669-014

Accept

N900040100

Setup Start

NS1

Revision ID:

Item Name: Skidtube RH

Stop

NS2

Start Date: 29/05/2012 Start Qty: 1.00 *1*

Cust Item ID:

Required Date: 16/07/2012 Req'd Qty: 1.00 *1*

Customer:

Reference:

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	*NR1*
	QC:	Date:	SPC (Y/N):	Date:		Stop	*NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 *120* QC Quality Control	QC4- 100% Inspect kits for completeness	0.00	DAS 16 9-00	12/07/23					

130 *130* Packaging Packaging	Packaging	0.00
	Memo	0.00
	Identify and pack for shipping as per PPPD209-669-014 Location: <u>SNIP</u>	

12/07/23 C

140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00
	Memo	0.00

MLJ 12/07/23

12/07/23

W/O:		WORK ORDER CHANGES					
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Picklist Print

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Work Order ID: 84916

Parent Item: D209-669-014

Parent Item Name: Skidtube RH

84916
D209-669-014

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

Comments: New IPP 08.02.13 new issue EC, verified by:DD
IPP Rev:B 08-05-20 chg QTY of D2570 DD verified by:

D209-669-043

Replacement Skidtube

36334

1

D2917-2

D2917-2

1993

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
Mezz	2		
39205	1		
39206	1		
	110	Each	1.0000
			2
			2
		**	

D2918-2

D2918-2

Saddle RH

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>	
ST424	1		
52129	1		
110	Each	1.0000	2
			2

38494

12/7/1356

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST424	1	
52133	1	

W/O:		WORK ORDER CHANGES					
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Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Page 2

Work Order ID: 84916**Parent Item:** D209-669-014**Parent Item Name:** Skidtube RH***84916***
D209-669-014**Start Date:** 29/05/2012**Start Qty:** 1.00**Required Date:** 16/07/2012**Required Qty:** 1.00

AN4-51A

Purchased

No

110

Each

302.0000

8

8

**

*S *AN4-51A**
Bolt*sf* *h*Location Loc Qty Loc Code

362	200	
121181	200	<u>8</u>
ST361	102	
119798	30	
121584	72	

D2570

Manufactured

No

110

Each

711.0000

24

24

**

*S *D2570**
Bushing*sf* *h*Location Loc Qty Loc Code

ST011	711	
72960	41	
78586	9	
79493	12	
81956	24	
81957	400	<u>24</u>
82874	225	

MS21042L4

Purchased

No

110

Each

4,095.000

24

24

**

*S *MS21042L4**
Nut*12/7/13 sf* *h*Location Loc Qty Loc Code

ST300	4095	
119075	125	
121011	713	
121444	2957	<u>24</u>
121652	300	

W/O:		WORK ORDER CHANGES					
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Page 3

Work Order ID: 84916**Parent Item:** D209-669-014**Parent Item Name:** Skidtube RH***84916***
D209-669-014**Start Date:** 29/05/2012**Start Qty:** 1.00**Required Date:** 16/07/2012**Required Qty:** 1.00

AN5-36A

Purchased

No

110

Each

184.0000

4

4

**

AN5-36A

Bolt

Location Loc Qty Loc Code

340	134	
121181	34	
121652	100	
ST340	50	
121708	50	4

AN960JD516

NAS1149D0563J Purchased

No

110

Each

0.0000

8

8

**

AN960.JD516

Washer

MS21042L5

Purchased

No

110

Each

1,447.000

4

4

**

MS21042L5

Nut

Location Loc Qty Loc Code

300	500	
121652	500	
ST300	947	
108827	8	
116105	5	
116548	43	
117611	18	
119109	865	4
17651	8	

AN4-7A

Purchased

No

110

Each

124.0000

16

16

**

AN4-7A

Bolt

Location Loc Qty Loc Code

ST356	124	
117514	24	
120770	100	

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Work Order ID: 84916***84916***
D209-669-014**Parent Item:** D209-669-014**Parent Item Name:** Skidtube RH**Start Date:** 29/05/2012**Required Date:** 16/07/2012**Start Qty:** 1.00**Required Qty:** 1.00

AN960JD416

NAS1149D0463J Purchased

No

110

Each

30.0000

32

32

**

AN960.ID416

Washer

M121912 sf h

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST351	30	
116289	10	
119097	20	

D2929

Manufactured No

110

Each

86.0000

2

2

**

D2929

Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST021	86	
53564	86	

D2930

Manufactured No

110

Each

102.0000

2

2

**

D2930

Spacer

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST021	102	
53563	102	

D3405-041

Manufactured No

110

Each

6.0000

1

1

**

D3405-041

Lug Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST478	6	
62227	2	
77000	2	
82031	1	
82032	1	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
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NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 84916

Parent Item: D209-669-014

Parent Item Name: Skidtube RH

84916
D209-669-014

Start Date: 29/05/2012

Required Date: 16/07/2012

Start Qty: 1.00

Required Qty: 1.00

AN4C47A

Purchased

No

110

Each

48.0000

4

4

**

M122204 SJ

AN4C47A
Bolt

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST361	48	
118451	6	
119798	2	
121009	22	
121585	18	

MS21043-4

Purchased

No

110

Each

1,346.000

5

5

**

VH L

MS21043-4
Nut

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

FG	40	
104603	40	
ST301	1306	
119546	147	
121162	659	
121652	500	

D3405-043

Manufactured

No

110

Each

2.0000

1

1

**

84941 07/19

D3405-043

Lug Assembly

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
-----------------	----------------	-----------------

ST478	2	
82038	2	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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Picklist Print

May-29-12 1:09:03 PM

Page 6

Work Order ID: 84916**Parent Item:** D209-669-014**Parent Item Name:** Skidtube RH***84916***
D209-669-014**Start Date:** 29/05/2012**Start Qty:** 1.00**Required Date:** 16/07/2012**Required Qty:** 1.00

D3407-041

Manufactured No 110 Each 27.0000 1 1

*********D3407-041***
Tow Ring

86672

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST463	27	
82067	6	
82068	19	
82108	2	

D3456-1

Manufactured No 110 Each 156.0000 1 1

*********D3456-1***
Washer

SF

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
FG	7	
25701	7	
ST044	149	
80252	1	
<u>81876</u>	48	
<u>83584</u>	100	

D3417-5

Manufactured No 110 Each 78.0000 2 2

*********D3417-5***
Washer

12/17/1350

C

<u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
ST042	78	
78842	28	
83318	50	

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
 Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

DART SERVICE INSTRUCTION

TO AMEND INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B

INSTRUCTIONS:

1) FOR D209-669-011/-012/-013/-014 SKID TUBES @ CHANGE 003 AND SUBSEQUENT, MODIFY THE FOLLOWING:

- a) REPLACE THE D2968-041 TOW RING WITH THE D3407-041 TOW RING ASSEMBLY.
- b) REPLACE THE D2736-1 AND D2736-3 GHW LUGS WITH THE D3405-041 AND D3405-043 LUG ASSEMBLIES.
- c) AMEND THE PARTS LIST IN SECTION 5.0 OF INSTALLATION INSTRUCTIONS IIN-D209-669 REV. B AS SHOWN ON PAGE 2 OF THIS DSI.

NOTE: ALL INSTALLATION FASTENERS FOR THE ABOVE CHANGES HAVE BEEN UPDATED. SEE THE AMENDED PARTS LIST ON PAGE 2 FOR DETAILS.

SHOP COPY
RETURN TO
ENGINEERING
UNCONTROLLED COPY
SUBJECT TO AMENDMENT
WITHOUT NOTICE
WORK ORDER
NO. 84916 MLJ
12/05/30

A	NEW ISSUE		AJS	09.02.24
REV.	DESCRIPTION		BY	DATE
DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	DRAWING NO. DSI 9450	REV. A SHEET 1 OF 3
DRAWN	AJS			
CHECKED		TITLE SKIDTUBE INSTALLATIONS	SCALE NTS	
MFG. APPR.	N/A			
APPROVED	<i>MLJ</i>			
DE APPR.	<i>MLJ</i>			
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD		

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

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			Initial Chief Eng	Action Description Chief Eng	Sign & Date				

NOTE: Date & initial all entries

5.0 PARTS LIST

ITEM	QTY -011	QTY -012	QTY -013	QTY -014	QTY -041	QTY -043	PART NUMBER	DESCRIPTION
	X						D209-669-011	SKIDTUBE INSTALLATION, LH (AH-1W/J)
		X					D209-669-012	SKIDTUBE INSTALLATION, RH (AH-1W/J)
			X				D209-669-013	SKIDTUBE INSTALLATION, LH (AH-1P/F/S)
				X			D209-669-014	SKIDTUBE INSTALLATION, RH (AH-1P/F/S)
1	1				X		D209-669-041	REPLACEMENT SKIDTUBE (AH-1W/J)
			1	1		X	D209-669-043	REPLACEMENT SKIDTUBE (AH-1P/F/S)

IS:

50	4	4	1	1			D3405-041	LUG ASSEMBLY
51	8	8	4	4			AN4C47A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21043-4	NUT
54			1	1			D3405-043	LUG ASSEMBLY
60	1	1	1	1			D3407-041	TOW RING ASSEMBLY
61	1	1	1	1			D3456-1	WASHER
62	1	1	1	1			MS21043-4	NUT
63	2	2	2	2			D3417-5	WASHER

WAS:

50	4	4	1	1			D2736-1	GHW LUG
51	8	8	4	4			AN4-46A	BOLT
52	16	16	8	8			D2570	BUSHING
53	8	8	4	4			MS21042L4	NUT (OR MS21042-4)
54			1	1			D2736-3	GHW LUG
60	1	1	1	1			D2968-041	TOW RING
61	1	1	1	1			AN970-4	WASHER
62	1	1	1	1			MS21042L4	NUT (OR MS21042-4)

DESIGN	AJS	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
DRAWN	AJS		
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 2 OF 3
APPROVED	JAY	TITLE	SCALE
DE APPR.		SKIDTUBE INSTALLATIONS	NTS
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT THE EXPRESS WRITTEN CONSENT OF DART AEROSPACE LTD.	

8491

W/O:		WORK ORDER CHANGES							
DATE	STEP	PROCEDURE CHANGE			By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

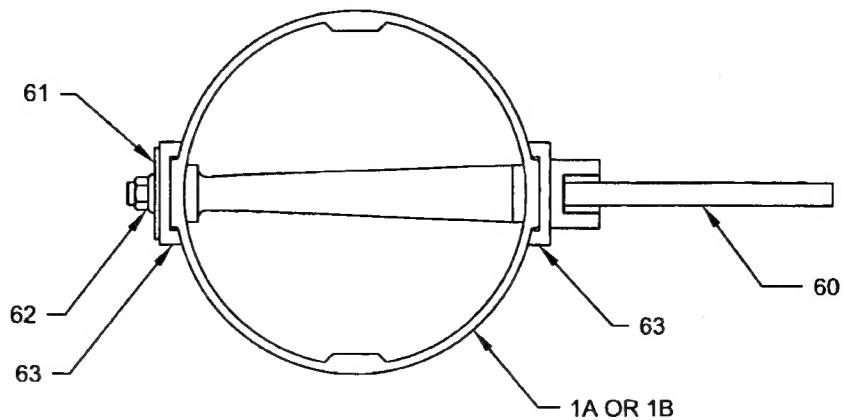
Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____
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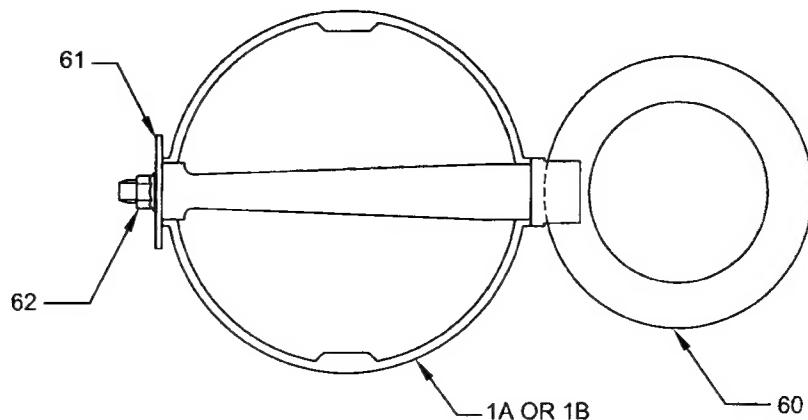
NOTE: Date & initial all entries

INSTALL TOW RING ASSEMBLY AS SHOWN BELOW (REFER TO SECTION F-F OF IIN-D209-669 REV. B.

IS:



WAS:



NO PICTORIAL CHANGE REQUIRED FOR GROUND HANDLING WHEEL LUG CHANGES.

DESIGN	AJS	DART AEROSPACE LTD	
DRAWN	AJS	HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.	N/A	DSI 9450	SHEET 3 OF 3
APPROVED	<i>MJ</i>	TITLE	SCALE
DE APPR.	<i>MM</i>	SKIDTUBE INSTALLATIONS	NTS
DATE	09.02.24	COPYRIGHT © 2009 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT AN OFFICIAL LICENSE FROM DART AEROSPACE LTD	

C49101

W/O:		WORK ORDER CHANGES							
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